

OK

Date: Wednesday, 04/06/2008 3:07:17 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SEAT BACK PAN (AFT FACING LH/RH)		
Job Number	: 39704		Part Number	: D37743		
Estimate Number	: 13363		Drawing Number	: D3774 PROTOTYPE		
P.O. Number	:		Project Number	: 00196		
This Issue	: 04/06/2008	S.O. No. :	Drawing Revision	: A 08.06.04		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : THERMOFORMING	Due Date	: 10/06/2008 Qty: 2 Um: Each		
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	: Est. REV:A New Issue 08.06.04 DL					

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
		Set up machine program D3774-3	
		Set up clamping frame as per folio	DL 08.06.05
2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET	
Comment: Qty.: 10.6670 sf(s)/Unit Total : 21.3340 sf(s) GE PLASTICS LEXAN SHEET M 105330. DL 08.06.05			
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
		1) Cut Blanks	DL 08.06.05 x2
4.0	THERMOFORMING	THERMOFORMING MACHINE	
Comment: THERMOFORMING MACHINE			
		Thermoform as per Dwg. D32811and Folio FTA 011	
	Dwg. Rev. <u>A</u>	Folio Rev. <u>P</u>	DL 08.06.05 x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK PAN (AFT FACING LH/RH)

Job Number: 39704

Part Number: D37743

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
6.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING	<i>DL 08.06.05</i>
	1) Trim to Finished Dimensions	<i>DL 08.06.06</i>
7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>x2</i>
	1) Check Surface finish for undesired marks, voids, dimples etc.	<i>DL 08.06.06</i>
	2) Check dimensions to ensure conformity to drawing tolerances.	
8.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<i>Engineering Approval 08.06.06 (2)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 00196 A Testing <i>08.06.06 (2)</i>
	Comment: PACKAGING RESOURCE #1	
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>08.06.06 (2) Placque</i>
Job Completion		<i>W 08.06.11</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thermo

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-769

Job #: 00196

Date: 08.04.23

Product Name: Aft Facing Seat

Requested By: CP

Design Manager Approval:

DART AEROSPACE LTD	WORK ORDER:	39704
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

(Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	197
Free of visual flaws (bumps, cracks, voids, etc.)	197

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D 3774 Rev. A and record below

Measured by:	<i>Dh.</i>	Audited by:	<i>/</i>	Prototype Approval:	<i>/</i>
Date:	<i>08-06-06</i>	Date:	<i>08-06-06</i>	Date:	<i>08-06-06</i>

Rev	Date	Change	Revised by	Approved
		New Issue		



Attn: CHANTAL

GE Polymershapes

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 8/17/2007

YOUR PURCHASE ORDER : PO00004161

OUR SHIPPER NO: 078178

LINE ITEM #.1

QUANTITY: 81

DESCRIPTION: F60029 LEXAN GY3778 1/25 X 48 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

Receiving Report

Date:

07/08/16

Batch No:

M10530

Supplier:

G.E Polymershapes

Dart P/O:

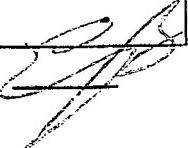
4161

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No N/A
 QC6 Inspection On Hold N/A
 Work Order N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 

Production/Admin:

Date

07/08/16

Location

Received/Costing

Initial

RSP 5411CG

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

** PLEASE NOTE: IF YOU WOULD LIKE TO HAVE FUTURE INVOICES
 FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS
 INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION**
 THANK YOU
 EMAIL/FAX INFO _____

PLEASE Remit To: GE Polymershapes 9150 Airport Road Brampton ON L6S 6G1 Tel: 905-789-3111 Fax: 905-789-3152

NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

8

7

6

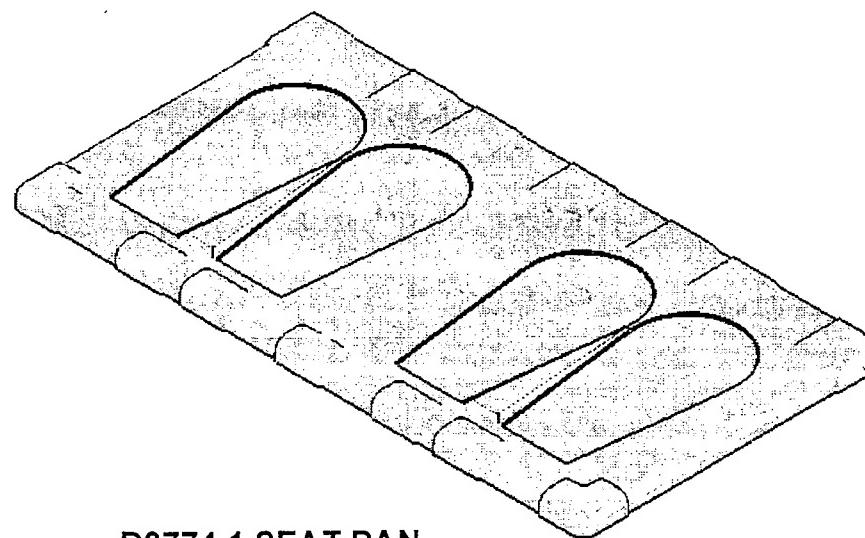
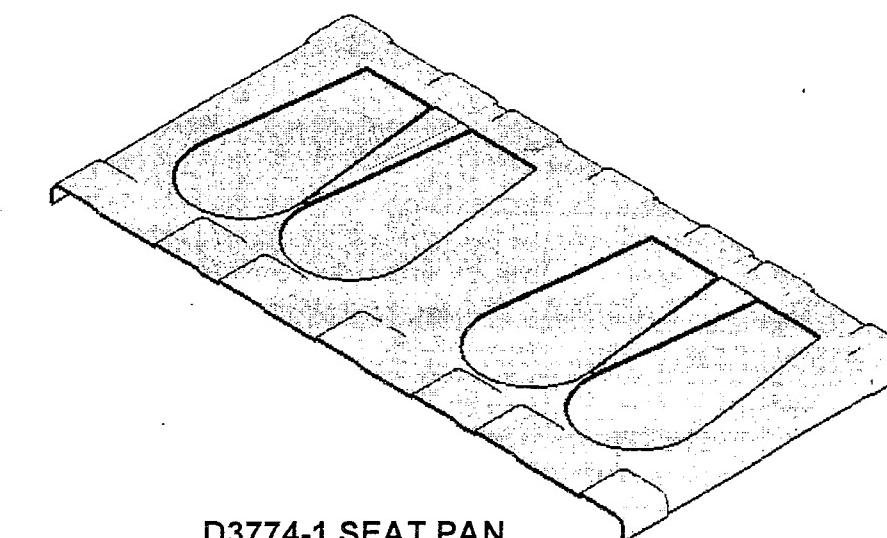
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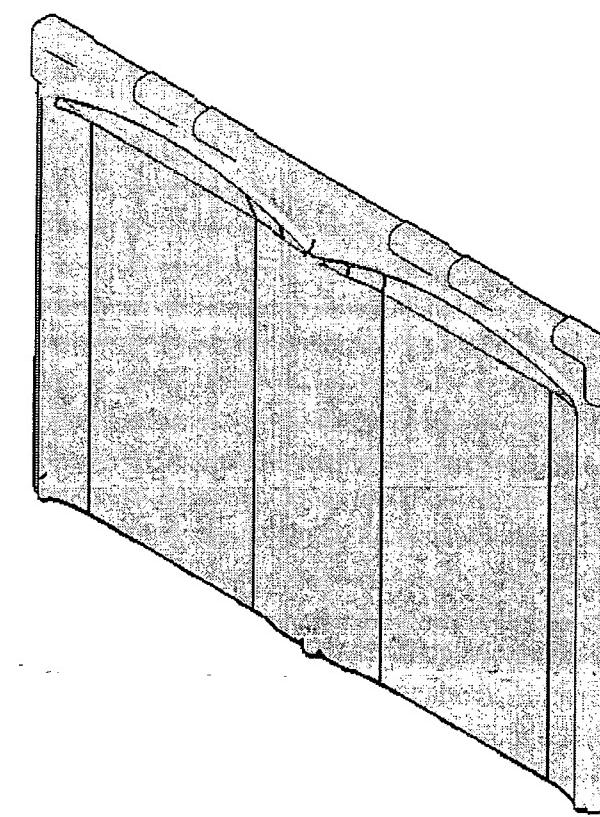
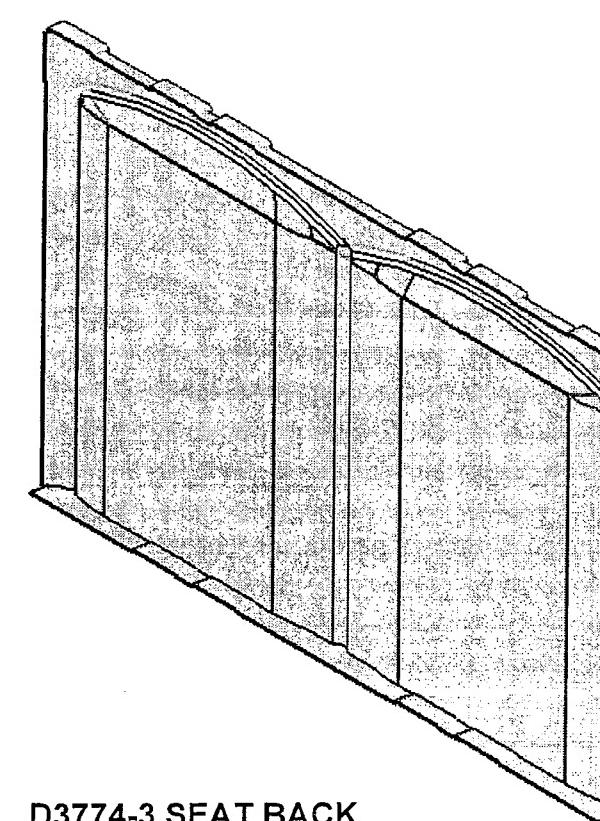
3

2

1

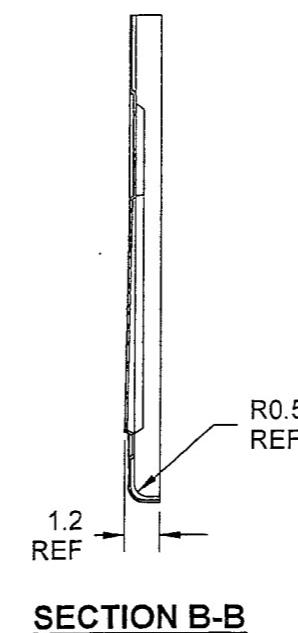
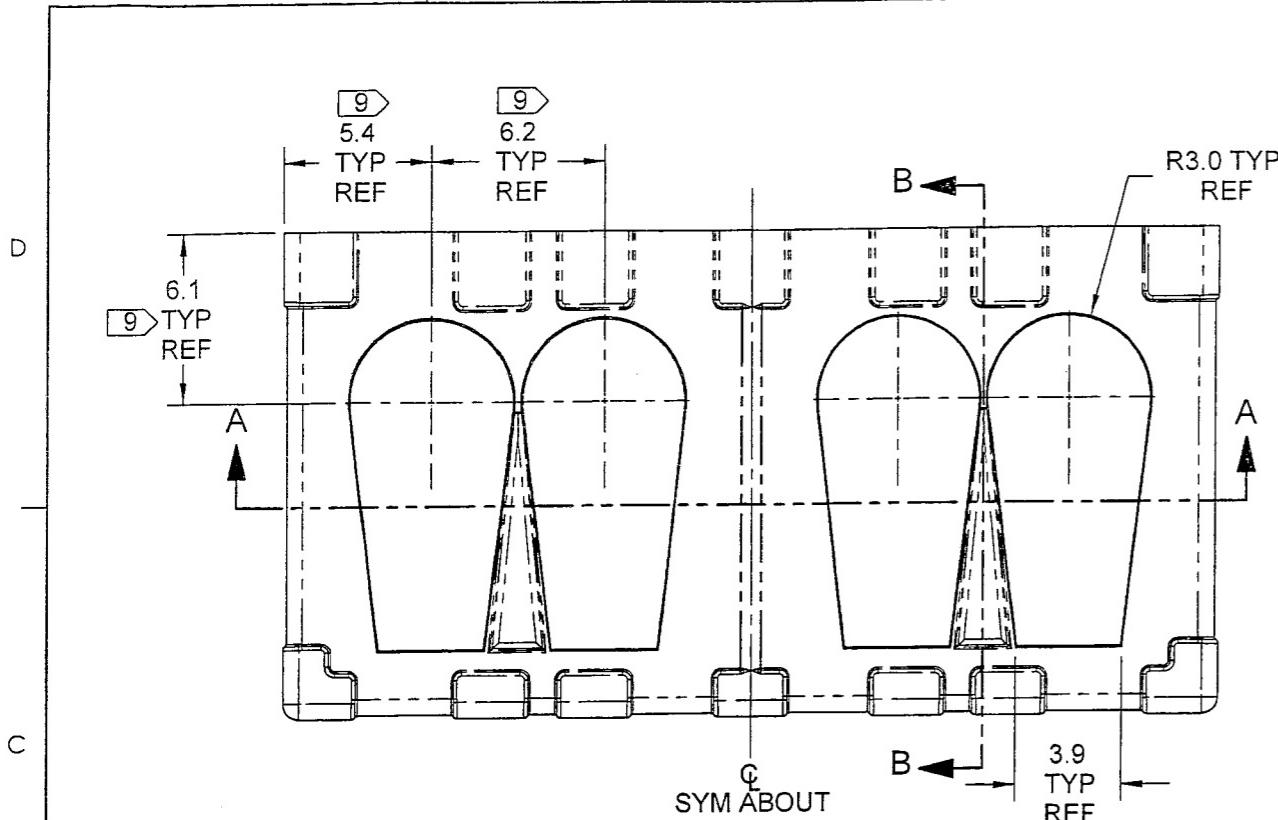
D3774-1 SEAT PAND3774-1 SEAT PAN
(REVERSE VIEW)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
AJS 08.06.04

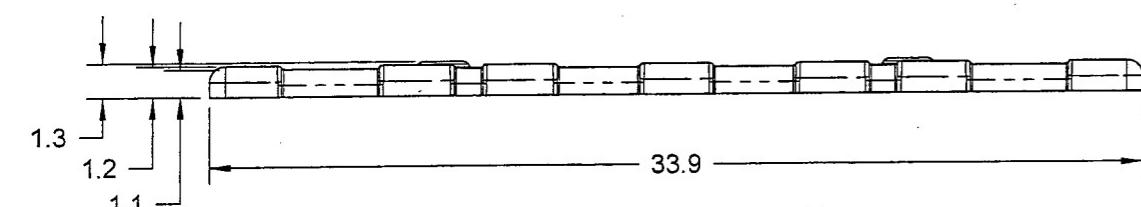
D3774-3 SEAT BACKD3774-3 SEAT BACK
(REVERSE VIEW)

A	NEW ISSUE	AJS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	
MFG. APPR.		D3774	REV. A
APPROVED		TITLE	SHEET 1 OF 3
DE APPR.		SEAT	SCALE
DATE	08.06.04	NTS	
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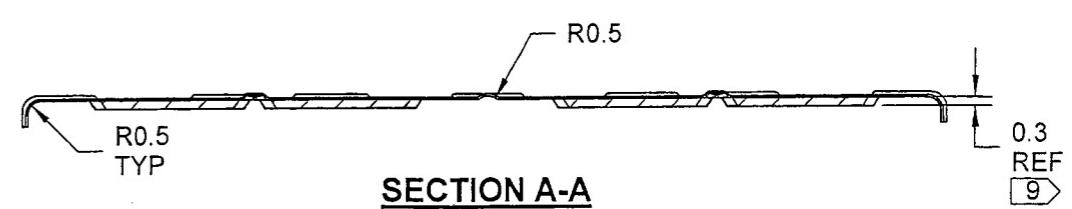
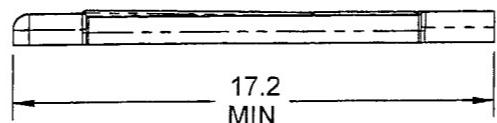
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SECTION B-B



D3774-1 SEAT PAN



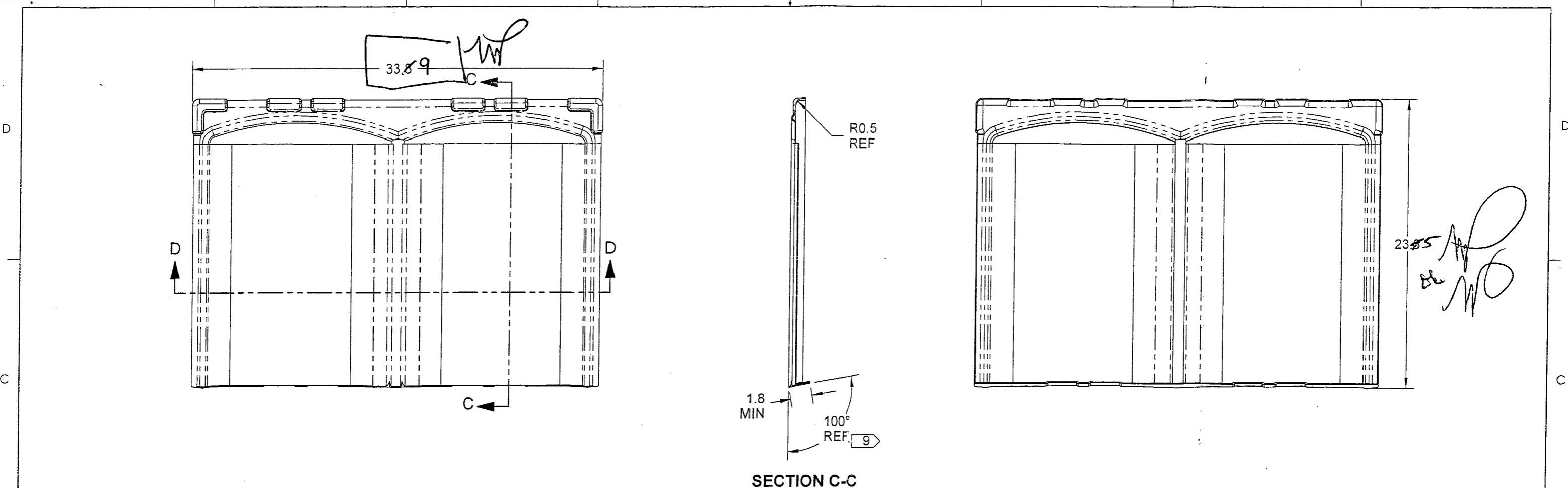
SECTION A-A

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
- 7) WEIGHT: D3774-1, 3.0 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9022.
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022 OR SOLIDWORKS GRAPHICS MODEL.
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING 0.06.

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO.
MFG. APPR.		REV. A D3774
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE SEAT
DATE	08.06.04	SCALE NTS
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8 7 6 5 4 3 2 1



SECTION C-C

1.3
1.1
0.5
REF 9
0.5
R0.5
R0.5
TYP

SECTION D-D

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
AJS 08.06.04

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT:D3774-2, 3.5 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023.
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023,
OR SOLIDWORKS GRAPHICS MODEL.
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING 0.06.

DESIGN	HS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3774
APPROVED		REV. A
DE APPR.		SHEET 3 OF 3
		SCALE
		NTS
DATE	08.06.04	TITLE SEAT

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